



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3319-7
Job Sheet 188518



Part No: D3319-7

Job Qty: 5 ea

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/10/19

Job Tracking No:

Due Date: 1/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 07-06-26 JLM IPP REV:C 17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	5 pcs	1/18/19	1/18/19	0.00	0.48	Waterjet - Flow		19/01/17
110	QC	5 pcs	1/18/19	1/18/19	0.00	0.00	QC2 Waterjet-2		19/01/17
120	QC	5 pcs	1/18/19	1/18/19	0.00	0.00	QC8-2		38
140	Brake NC	5 pcs	1/18/19	1/18/19	0.00	0.27	Brake NC 2		DAS 38
150	QC	5 pcs	1/18/19	1/18/19	0.00	0.00	QC6		38
160	Autoweld 1	5 pcs	1/18/19	1/18/19	0.00	0.71	Automated welding		38
170	QC	5 pcs	1/18/19	1/18/19	0.00	0.00	QC10		38
180	QC	5 pcs	1/18/19	1/18/19	0.00	0.00	QC5		38
190	HandFinish	5 pcs	1/18/19	1/18/19	0.00	0.00	HandFinish1		38
200	QC	5 pcs	1/18/19	1/18/19	0.00	0.00	QC5		38
210	Packaging	5 pcs	1/18/19	1/18/19	0.00	0.00	Packaging3-1		38
220	QC21-SA	5 Ea	1/18/19	1/18/19	0.00	0.00	QC21		38

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary
Descriptions: 140 - Form using DT8326 & DT8261 as per Dwg D3319 Rev: _____

160 - 8259 Hardcoat Rod 198901

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.
BATCH: 5144835

210 - Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-7, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	2.7500 sf (.55 ea)	100-Waterjet - Flow - 1	5076887

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	3	168	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190Inches	0.195		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

			+ 0.005 - 0.001	0.189
2	Wearplate	0.316Inches	+ 0.006 - 0.001	0.322 0.315
3	Wearplate	0.607Inches	± 0.010	0.617 0.597
4	Wearplate	0.600Inches	± 0.030	0.630 0.570
5	Wearplate	2.690Inches	± 0.010	2.700 2.680
6	Wearplate	3.526Inches	± 0.010	3.536 3.516
7	Wearplate	4.520Inches	± 0.030	4.550 4.490
8	Wearplate	5.063Inches	± 0.010	5.073 5.053
9	Wearplate	6.160Inches	± 0.030	6.190 6.130
10	Wearplate	11.650Inches	± 0.010	11.660 11.640
11	Wearplate	12.750Inches	± 0.030	12.780 12.720
12	Wearplate	0.048Inches	± 0.010	0.058 0.038
13	Wearplate	0.500Inches	+ 0.006 - 0.010	0.506 0.490
14	Wearplate	0.504Inches	± 0.010	0.514 0.494

Plex 1/10/19 12:08 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐									
Date : _____	St: _____	QTY Effective : _____			MRB (QSI042) Approval						
Description Work					Completed By						
					Lead hand / Supervisor Approval Verification						
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